

82326

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

4

Start Date: 28/03/2012 **Start Qty:** 400

Cust Item ID:

Required Date: 11/04/2012 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/29 Tooling:

Date:

Run Start *NR1*

QC:

Date: _____ **SPC (Y/N):** _____

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2666	Rev D								
100		0.00							
100	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00		PD/RK 12/06/27		10			
HAAS CNC vertical machine #1	Program batch number.1-Inspect part number and batch number are programmed correctly.4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet 6			FK 12/06/28					
110		0.00							
110	CONVENTIONAL MILLING MACHINE								
Mill Conv	Memo	0.00		FK 12/06/28		10			
Conventional Milling Machine	Machine Keyway and inspect per attached dimension sheet								
120		0.00							
120	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00		PD/RK 12/06/27		10			
Quality Control				FK-12/06/28					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82326

March-28-12 4:02:30 PM

82326

Page 2

Item ID: D2666-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, RH Fwd Aft In 206
 Start Date: 28/03/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 11/04/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00		ml 12/07/03		10	✓		
Quality Control									

140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00				10	246	12.74	
Hand Finishing									

150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 10:30 OVEN TEMPERATURE:								
	FINISH TIME: 11:00								

ml 12/841

3200F

11:00

10X ✓

ml 12/07/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82326

March-28-12 4:02:30 PM

82326

Page 3

Item ID: D2666-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, RH Fwd Aft In 206

Start Date: 28/03/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/04/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

10 ϕ 12/2-7-4

170

Identify as per dwg & Stock Location: 427

0.00

170

Packaging

Memo

0.00

Packaging

10 12/07/04 AB

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/7/5

ME
12-07-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-28-12 4:02:34 PM

Page 1

Work Order ID: 82326

82326

Parent Item: D2666-2

D2666-2

Parent Item Name: Saddle, RH Fwd Aft In 206

Start Date: 28/03/2012

Required Date: 11/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house processEC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-001		Manufactured	No			100	Each	41.0000	1	4			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D6101-001

Saddle Billet

**

90

12/06/26

Location

Loc Qty

Loc Code

MAT040

3

69677

2

76836

1

MAT041

38

80764

38

→ 81923

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order: 82326	
Description: 206 Saddle, Inboard, Right side				Part Number: D2666-2	
Inspection Dwg: D2666 Rev: D DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		0.119	.122	.122	.121	.120
B	0.100	0.140		0.111	.112	.112	.112	.112
C	2.470	2.510		2.491	2.492	2.492	2.492	2.492
D	0.100	0.180		0.130	.130	.130	.130	.130
E	0.210	0.230		0.229	.225	.227	.227	.225
F	1.313	1.343		1.327	1.330	1.331	1.330	1.330
G	0.240	0.260		0.260	.260	.260	.260	.259
H	0.615	0.685		0.670	.657	.655	.655	.655
I	1.125	1.145		1.133	1.132	1.133	1.131	1.131
J	0.990	1.010		1.003	1.003	1.003	1.003	1.003
K	0.235	0.240		0.238	.238	.238	.237	.237
L	0.510	0.515		0.512	.512	.512	.512	.512
M	0.100	0.120		0.112	.113	.113	.112	.112
N	1.565	1.585		1.575	1.572	1.573	1.572	1.571
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500
R	0.490	0.510		0.496	.500	.500	.500	.500
S	0.312	0.318		0.317	.314	.314	.314	.314
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362
V	0.315	0.322		0.317	.317	.317	.317	.317
W	0.540	0.560		0.549	.550	.550	.550	.550
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679
Y	0.256	0.262		0.258	.258	.258	.258	.258
Z	0.178	0.198		0.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: M / RF / F.K.	Date: 12/06/27
Audited by: [Signature]	Date: 12/07/03
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension S and Y revised	KJ	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 82326
Description: 206 Saddle, Inboard, Right side		Part Number: D2666-2
Inspection Dwg: D2666 Rev: D DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
A	0.100	0.140		.115	.116	.113	.112	.120
B	0.100	0.140		.112	.110	.113	.112	.112
C	2.470	2.510		2.492	2.492	2.492	2.492	2.492
D	0.100	0.180		.130	.130	.130	.130	.130
E	0.210	0.230		.225	.224	.225	.225	.225
F	1.313	1.343		1.330	1.329	1.329	1.330	1.330
G	0.240	0.260		.255	.255	.255	.258	.258
H	0.615	0.685		.655	.655	.655	.655	.655
I	1.125	1.145		1.134	1.136	1.134	1.134	1.1325
J	0.990	1.010		1.003	1.003	1.003	1.003	1.003
K	0.235	0.240		.237	.237	.237	.237	.237
L	0.510	0.515		.512	.512	.512	.512	.512
M	0.100	0.120		.112	.112	.112	.112	.112
N	1.565	1.585		1.574	1.575	1.574	1.574	1.573
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500
R	0.490	0.510		.500	.500	.500	.500	.500
S	0.312	0.318		.314	.314	.314	.314	.314
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362
V	0.315	0.322		.317	.317	.317	.317	.317
W	0.540	0.560		.550	.550	.548	.548	.550
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679
Y	0.256	0.262		.258	.258	.258	.258	.258
Z	0.178	0.198		.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: F.K.	Date: 12/06/28
Audited by: <i>mf</i>	Date: 12/07/03
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension S and Y revised	KJ	<i>M</i>

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2666	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD INSIDE HIGH		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; ϕ 0.316 WAS ϕ 0.313	

RELEASED

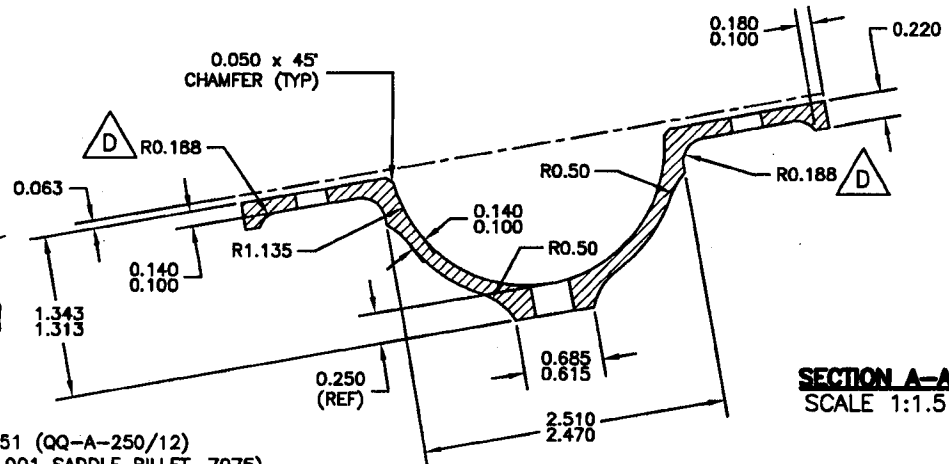
07.02.12

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO.

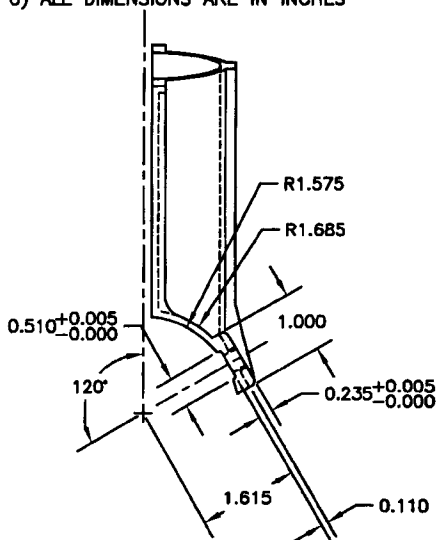
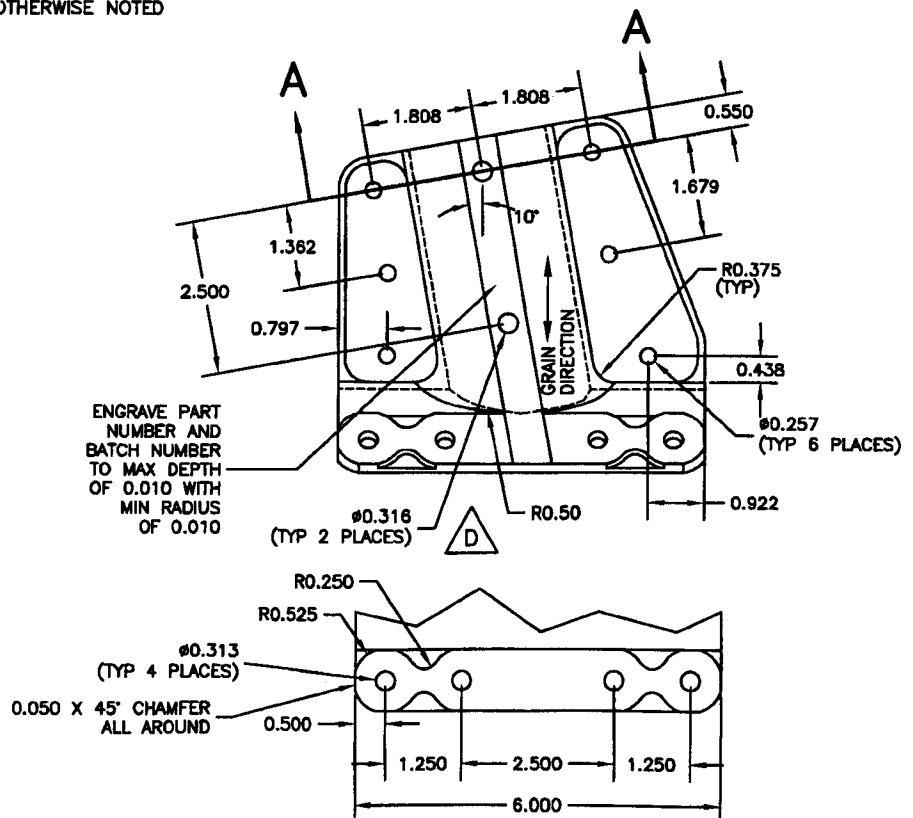
82326 MLJ

12/03/29



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

**D2666-1 SADDLE FWD INSIDE HIGH**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries